

shy May 14

Trimmed

Work Order ID 84249

\*84249\*

Page 1

May-08-12 12:58:13 PM

Item ID: D4640-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: RH Aft Wall Protector

Start Date: 08/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: 12/05/08

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4640	A

100 0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg

Prog Rev: *A*

Dwg Rev: *A*

Deburr as required

110 0.00

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

*1 0* *Jm/2*  
*12-5-9*

*1 0* *Jm/2*  
*12-5-9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84249

**\*84249\***

Page 2

May-08-12 12:58:13 PM

Item ID: D4640-9

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: RH Aft Wall Protector

Start Date: 08/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

12-05-09

130

Identify as per dwg & Stock Location:

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

PP84242

1x SP 12-5-9

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/5/10  
MF  
12-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-08-12 12:58:17 PM

Page 1

Work Order ID: 84249

\*84249\*

Parent Item: D4640-9

\*D4640-9\*

Parent Item Name: RH Aft Wall Protector

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	272.7275	2.385	2.510526			

\*MI FXS 093-F6006-02\*

\*\*

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

272.7274879

106751

97.9159079

110877

174.81158

110877

JM 151  
12-5-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

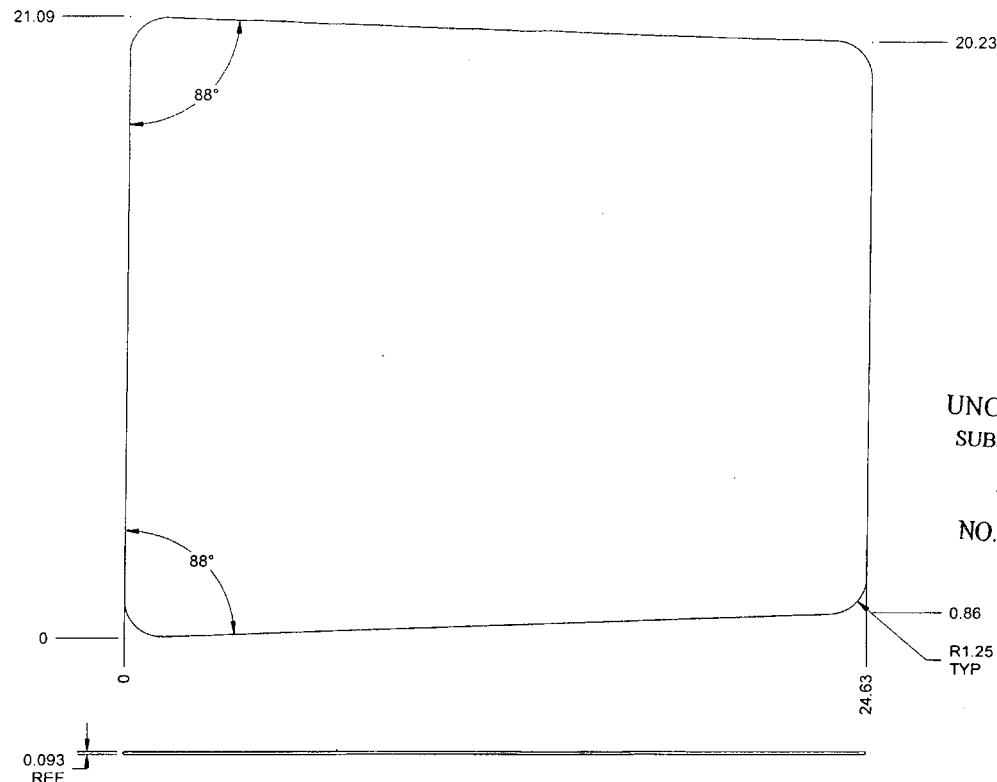
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 84249 MLJ  
12/05/08

RELEASED  
R 2012-05-07  
MP

**D4640-1 RH FORWARD WALL PROTECTOR**  
TEXTURED SIDE SHOWN

**NOTES:**

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 2.00 lbs
- 8) CHECK PER TEMPLATE DT8924

REV.	NEW ISSUE	DESCRIPTION	DC	12.04.20
DESIGN	JE		BY	DATE
DRAWN	JC			
CHECKED	JE			
MFG. APPR.	JE			
APPROVED	JE			
DE APPR.	JE			
DATE	12.04.20			

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D4640**

REV. A

SHEET 1 OF 9

TITLE

**BAGGAGE PROTECTOR**

SCALE

NTS

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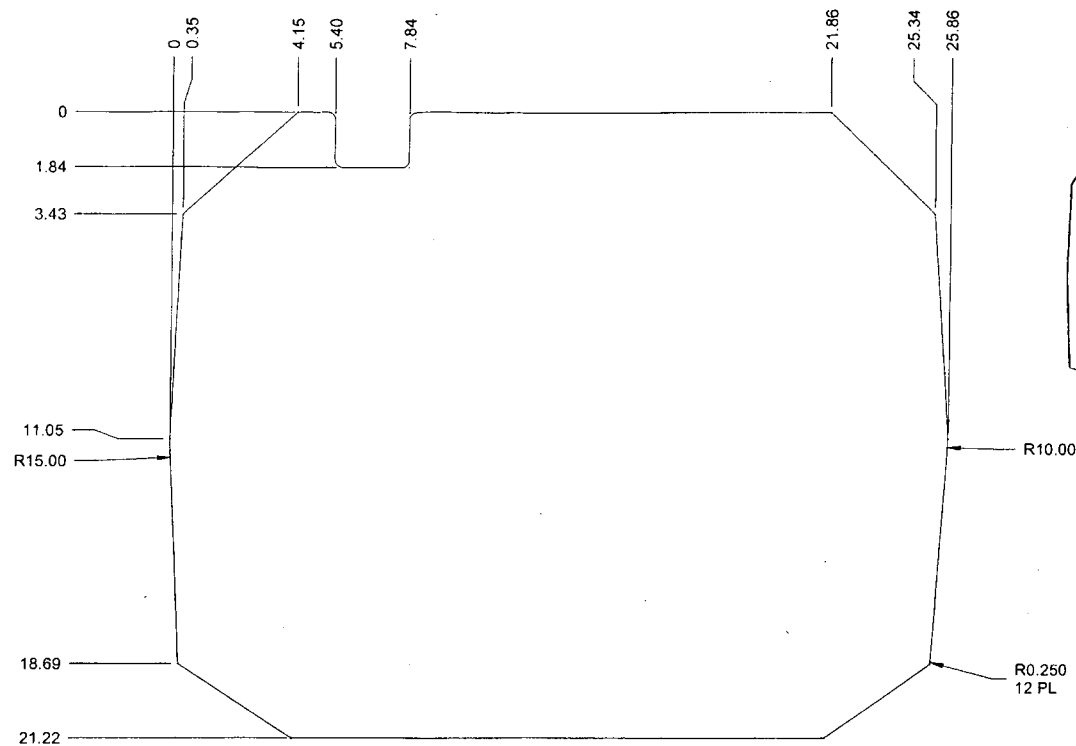
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4640-3 FORWARD WALL PROTECTOR**  
TEXTURED SIDE SHOWN

RELEASED  
2012-05-07  
JMP

**NOTES:**

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 2.07 lbs
- 8) CHECK PER TEMPLATE DT8925

DESIGN	JS	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JS	<b>D4640</b>	SHEET 2 OF 9
APPROVED	MD	TITLE	SCALE
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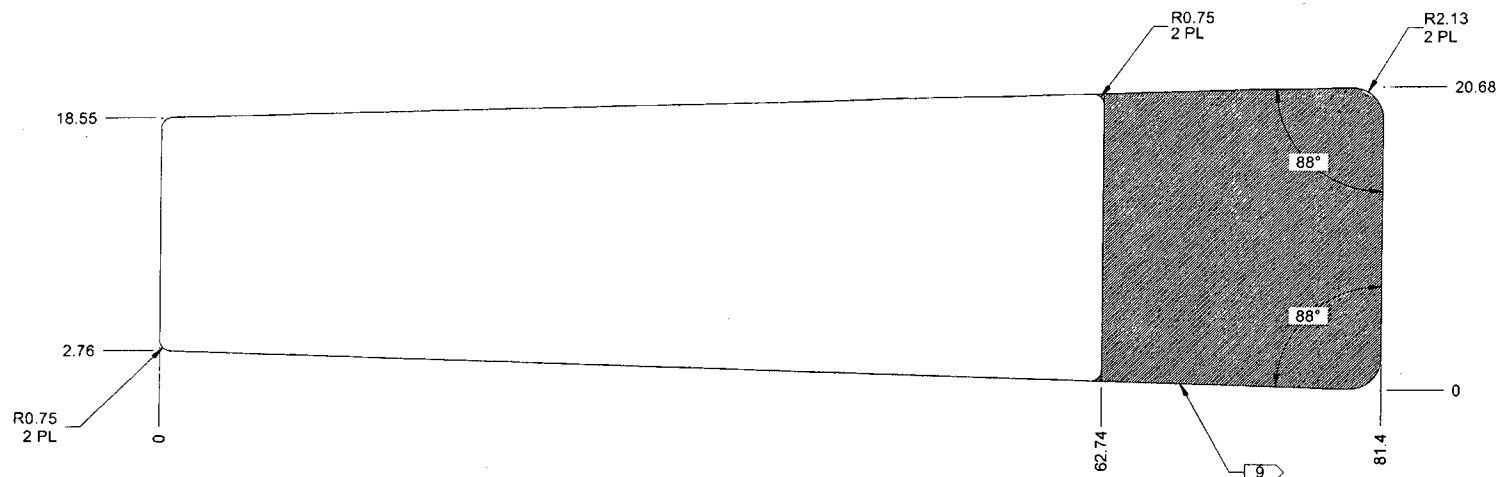
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4640-5 LH WALL PROTECTOR**  
TEXTURED SIDE SHOWN

**NOTES:**

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 6.00 lbs (TRIMMED WEIGHT = 4.49 lbs)
- 8) CHECK PER TEMPLATE DT8926
- 9) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

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2012-05-07  
WJ

84249

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D4640-7 AFT WALL PROTECTOR**  
TEXTURED SIDE SHOWN

- NOTES:  
 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
 REF DART SPEC MLEXX.093-F6006-02  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE  
 7) WEIGHT: 1.34 lbs  
 8) CHECK PER TEMPLATE DT8927

DESIGN	AB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	EE	D4640	SHEET 4 OF 9
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 MP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

25<sup>2</sup> x 18<sup>11</sup>

84249

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2012-05-07  
MP

**D4640-9 RH AFT WALL PROTECTOR**  
TEXTURED SIDE SHOWN

**NOTES:**

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.65 lbs
- 8) CHECK PER TEMPLATE DT8928

DESIGN	<i>JE</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JE</i>	D4640	SHEET 5 OF 9
APPROVED	<i>MP</i>	TITLE	SCALE
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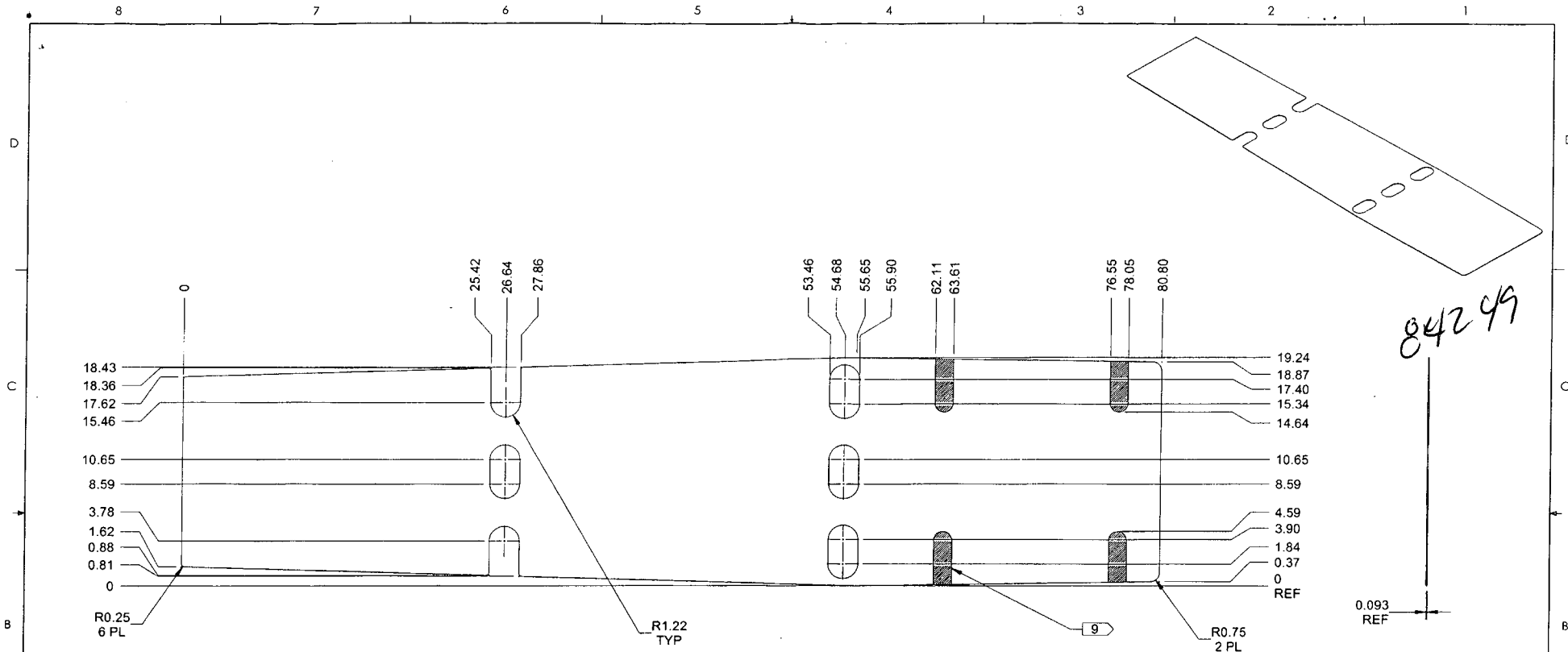
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4640-11 FLOOR PROTECTOR**  
TEXTURED SIDE SHOWN

RELEASED  
R 2012-05-07  
JND

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.66 lbs (TRIMMED WEIGHT = 5.56 lbs)
- 8) CHECK PER TEMPLATE DT8929
- 9) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

DESIGN	BC	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	D4640	SHEET 6 OF 9
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

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2

1

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C

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A

A

0.093  
REF

16.75

9.59

R0.50  
4 PL

6.84

0.67

0

1.50

**D4640-13 DOOR PROTECTOR**  
TEXTURED SIDE SHOWN

89°

89°

17.43

R3.50  
4 PL

0

27.25

84249

RELEASED  
2012-05-07  
JW

## NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.78 lbs
- 8) CHECK PER TEMPLATE DT8930

DESIGN	BE	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D4640	SHEET 7 OF 9
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8

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1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

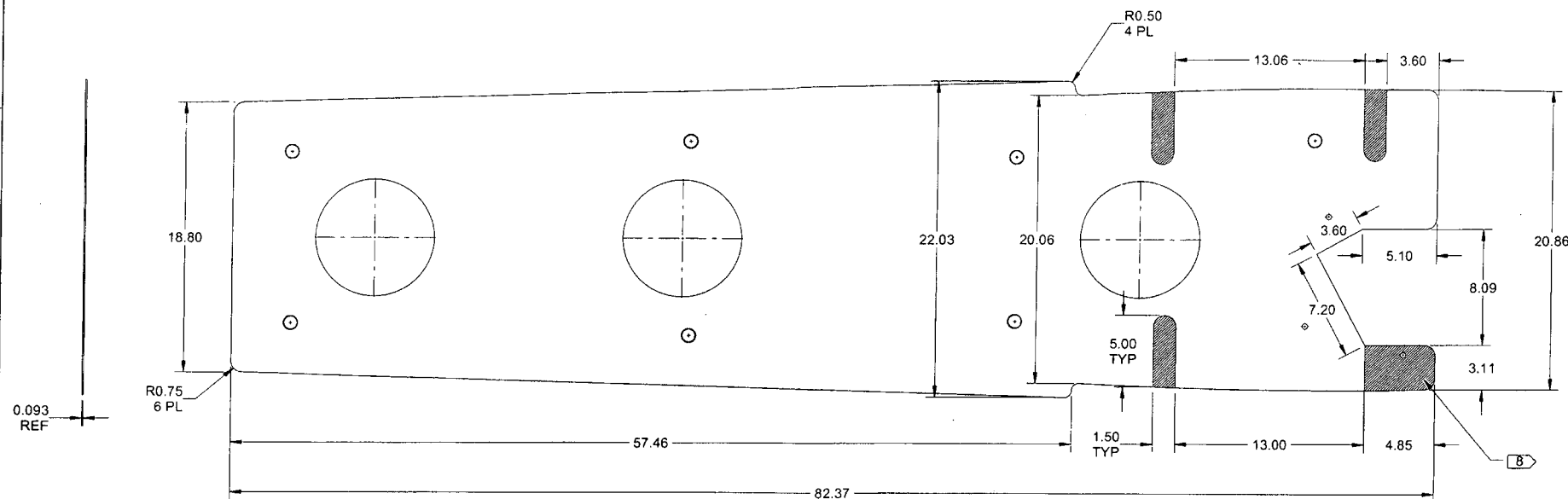
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

84249



**D4640-15 CEILING PROTECTOR**  
TEXTURED SIDE SHOWN

RELEASED  
2012-05-07

**NOTES:**

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.84 lbs (TRIMMED WEIGHT = 5.84 lbs)
- 8) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

DESIGN	XDF	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EE	DRAWING NO.	REV. A
MFG. APPR.	EE	D4640	SHEET 8 OF 9
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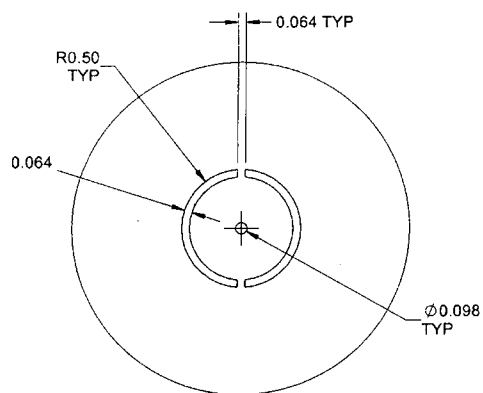
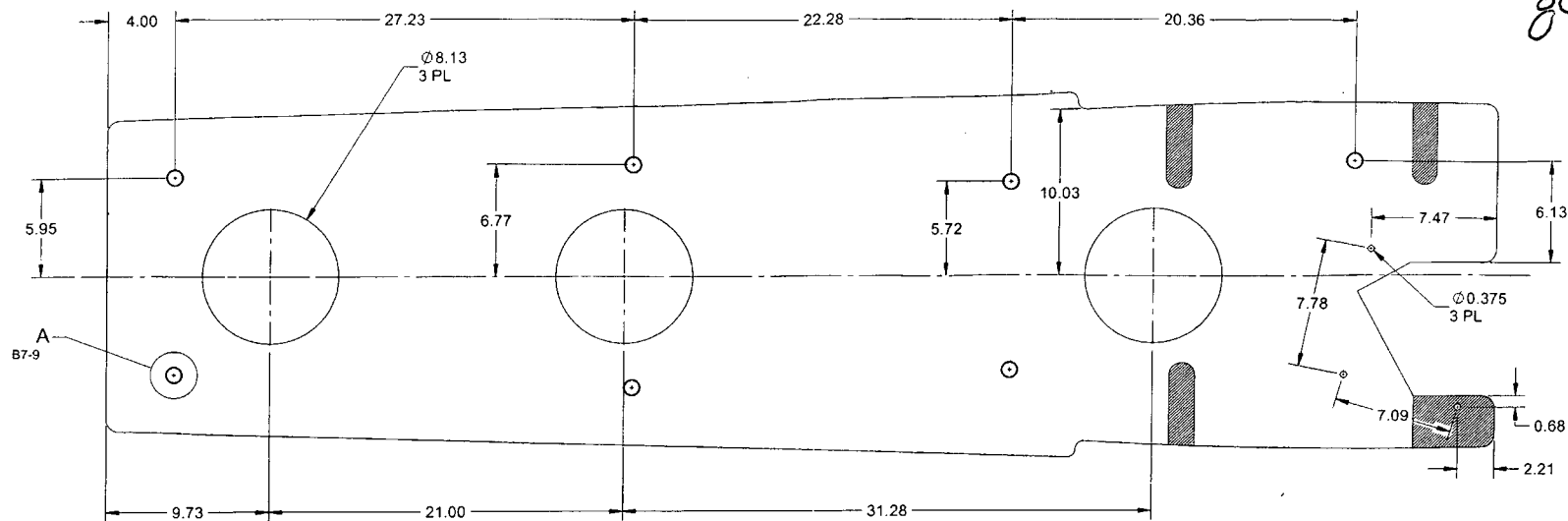
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DETAIL A**  
7 PL  
C7-9

**D4640-15 CEILING PROTECTOR**  
SUPPLEMENTAL VIEW

RELEASED  
2012-05-07  
ND

DESIGN	XDF	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EC	DRAWING NO.	REV. A
MFG. APPR.	EC	<b>D4640</b>	SHEET 9 OF 9
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	<b>BAGGAGE PROTECTOR</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries